



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3110
Job Sheet 179152



Part No: 646.3110

Job Qty: 12 ea

Part Name: Channel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 7/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3100 REV N/C IPP REV:A NEW ISSUE 12-10-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea			0.00	0.00	Start Up Machining-1		///
100	Bandsaw	12 pcs			0.00	0.66	Bandsaw1		///
110	CNC Vertical Machining	12 pcs			0.43	13.33	HAAS1-1		///
120	QC	12 pcs			0.00	0.00	QC2 Machining-1		///
130	QC	12 pcs			0.00	0.00	QC8 Machining-1		///
140	Outsource	12 pcs					ATG001-VC		18/10/12 DAS
150	Packaging	12 pcs			0.00	0.00	Packaging2		15/10/18 13
155	QC	12 pcs			0.00	0.00	QC5		38
180	Packaging	12 pcs			0.00	0.00	Packaging3-1		NOV 06 2018
190	QC21-SA	12 Ea			0.00	0.00	QC21		NOV 06 2018

Part Op 100 - Cut Blank at 15.00"

Descriptions: 110 - 1-Machine per folio FB145

140 - Issue P/O to ATG : _____ 1- Hard Anodize Black and Prime as per Dwg 646.3100

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.500X1.500 *slo2373x11	7075-T6S Sheet 1.5" Thick Plate X 1.5" Wide	15 ft (1.25 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.500X1.500	15	10	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Channel	14.600inches ± 0.010	14.610 14.590		
2	Channel	13.130inches ± 0.010	13.140 13.120		
3	Channel	0.090inches ± 0.010	0.100 0.080		
4	Channel	0.470inches ± 0.010	0.480 0.460		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
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				QC / QA Coordinator Approval																	
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OTHER : _____																					

5	Channel	0.750inches $\pm$ 0.010	0.760 0.740	
6	Channel	83.000Degrees $\pm$ 0.500	83.500 82.500	Angle
7	Channel	0.880inches $\pm$ 0.010	0.890 0.870	
8	Channel	0.645inches $\pm$ 0.005	0.650 0.640	
9	Channel	0.110inches $\pm$ 0.010	0.120 0.100	
10	Channel	0.120inches $\pm$ 0.010	0.130 0.110	
11	Channel	0.209inches + 0.005 - 0.001	0.214 0.208	Diameter
12	Channel	0.409inches $\pm$ 0.005	0.414 0.404	
13	Channel	0.420inches $\pm$ 0.002	0.422 0.418	
14	Channel	2.188inches $\pm$ 0.002	2.190 2.186	
15	Channel	2.188inches $\pm$ 0.002	2.190 2.186	
16	Channel	2.188inches $\pm$ 0.002	2.190 2.186	
17	Channel	2.187inches $\pm$ 0.002	2.189 2.185	
18	Channel	0.785inches $\pm$ 0.002	0.787 0.783	
19	Channel	2.395inches $\pm$ 0.002	2.397 2.393	
20	Channel	0.669inches $\pm$ 0.002	0.671 0.667	
21	Channel	0.372inches $\pm$ 0.002	0.374 0.370	
22	Channel	0.334inches $\pm$ 0.002	0.336 0.332	
23	Channel	0.175inches $\pm$ 0.002	0.177 0.173	
24	Channel	0.130inches $\pm$ 0.002	0.132 0.128	

Plex 6/14/18 10:54 AM Dart.lajeunesse.marie

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Hewittsburg, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartero.com
www.dartaerospace.com

DART
AEROSPACE

Container No: S117183



Part: 646.3110

Job No: 179152

Serial No/Batch: S117183

Revision:

Inspector:

Exp Date:

Instructions:

Date: 10/10/18

DQA:• _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD	Work Order:	
Description: Channel	Part Number:	646.3110
Inspection Dwg: 646.3100 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.60	+/-0.010	14.513	✓		high gage	
13.13	+/-0.010	13.125	✓		high gage	
0.09	+/-0.010	.090	✓		vernier	
0.47	+/-0.010	.480	✓		high gage	
0.75	+/-0.010	.750	✓		vernier	
83°	+/-0.5°	83°	✓		Gaborit	
0.88	+/-0.010	.876	✓		vernier	
0.645	+/-0.005	.646	✓		vernier	
0.11	+/-0.010	.109	✓		vernier	
0.12	+/-0.010	.115	✓		vernier	
Ø0.209	+0.005/-0.001	.209 Ø	✓		Ring gage	
0.409	+/-0.005	.408	✓		vernier	
0.420	+/-0.002	.418	✓		high gage	
2.188	+/-0.002	2.187	✓		vernier	
2.188	+/-0.002	2.187	✓		vernier	
2.188	+/-0.002	2.186	✓		vernier	
2.187	+/-0.002	2.185	✓		vernier	
0.785	+/-0.002	.786	✓		vernier	
2.395	+/-0.002	2.397	✓		vernier	
0.669	+/-0.002	.669	✓		vernier	
0.372	+/-0.002	.371	✓		high gage	
0.334	+/-0.002	.333	✓		high gage	
0.175	+/-0.002	.173	✓		high gage	
0.130	+/-0.002	.128	✓		high gage	

Measured by: <i>mm</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 2018/10/10	Date: 18/10/18	Date:

Rev	Date	Change	Revised by	Approved
A	13.09.17	New Issue	KJ	<i>[Signature]</i>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041337**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041337
PO Date: 10/12/18
Due Date: 11/9/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Belanger, NatashaPhone:

Attention: Lalande, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	181931-A	644.4117	Bracket, Fwd Pivot 1-ISSUE P/O TO ATG: _____ 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil- A-8625 Type 3 Class 2 3-Certification of Comformity is required 1-ISSUE P/O TO ATG: _____ 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil- A-8625 Type 3 Class 2 3-Certification of Comformity is required	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$8.10/pcs	\$8.10
3	181424	646.9713	Body Issue P/O to ATG : Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	-	11/9/18	40 pcs	0 pcs	40 pcs	\$15.55/pcs	\$622.00

Plex 10/24/18 2:36 PM dart.tsimiklis.chrisoula



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041337**

Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
4	181396	647.7811	Bracket B Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	-	11/9/18	50 pcs	0 pcs	50 pcs	\$15.55/pcs	\$777.50	
5	179152	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	-	11/9/18	11 pcs	0 pcs	11 pcs	\$11.70/pcs	\$128.70	
11 X OCT 31 2018												
6	183653	RBE350A93-3302-02-1	Handle -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 -Certificate of Conformity is required	Firmed	-	11/9/18	16 pcs	0 pcs	16 pcs	\$8.55/pcs	\$136.80	
7	176390	RBT18649-9-1	Top Plate -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	11/9/18	8 pcs	0 pcs	8 pcs	\$6.30/pcs	\$50.40	
Grand Total:											\$1,723.50	

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041337

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/24/18 2:36 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916365

Date: 29-Oct-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Christina Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
11 ea	Part: 646.3110 Channel Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23938	Rev: NC PO: PO041337	Line: 5
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>29/10/18</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

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Made in Canada.

